

Date: Tuesday, 19/08/2008 4:03:21 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE EXTRUSION
Job Number : 41418	
Estimate Number : 10050	
P.O. Number :	Part Number : D6207
This Issue : 19/08/2008 S.O. No. :	Drawing Number : D6207 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 37670	Material :
Written By :	Due Date : 05/09/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JLD 08.8.19</u>	
Comment : Est. A: 02.03.15 New Issue NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 7019C208/08/25

a) Description: Angle extrusion 25 ft long 1.000" x 1.000" x 0.125"

b) Material: 6061-T6/T6511 (QQ-A-200/8)

c) Minimum ultimate tensile strenght = 38 ksi

d) Minimum yield tensile strenght = 35 ksi

40 FT

2.0	D6207P	Angle Extrusion 1x1x.125
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Comment: Qty.: 1.0000 f(s)/Unit Total : 40.0000 f(s)
Angle Extrusion 1x1x.125

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

P2 8/8/27 48

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6207

Check hardness with Webster tester

8 08/12/11

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: 10 8/8/22 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/08-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

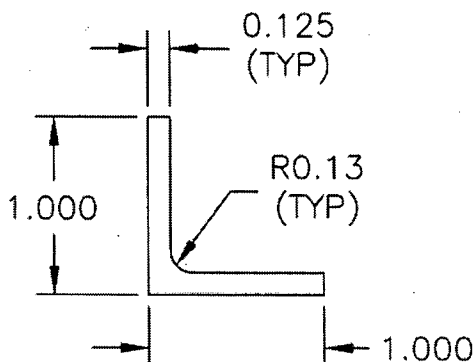
NOTE: Date & initial all entries



DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6207	REV. A SHEET 1 OF 1
DATE 02.03.13		TITLE ANGLE EXTRUSION	SCALE 1:1
A	02.03.13	NEW ISSUE	

RELEASED
02.03.13

SPECIFICATION CONTROL DRAWING



D6207-XXX ANGLE EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6207-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE
1.000" x 1.000" x 0.125"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4478

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MAGNA STAINLESS DIV. DE CSM INC.
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-0013

COMMANDE
SALES ORDER

0174395

DU À /
TO:

LIVRÉ À /
SHIP TO:

ART AEROSPACE LTD
270 ABERDEEN STREET
AWKESBURY
NTARIO

K6A 1K7

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

3/0 quick 13410

COMMANDE SALES ORDER		CODE DE CLIENT CUSTOMER CODE		BON D'ACHAT DU CLIENT CUSTOMER PURCHASE ORDER		N° DE TÉLÉPHONE DU CLIENT CUSTOMER TELEPHONE NUMBER		N° DE TÉLÉCOPIEUR DU CLIENT CUSTOMER FAX NO.	
0174395		DART		7019		613 632-5200		632-1053	
LIVRÉ VIA - ERIC VIA		CONDITIONS - TERMS		DATE COMMANDE DATE ORDERED		DATE REQUISE DATE REQUIRED		DATE LIVRÉE DATE DELIVERED	
NIR:R-557065-1		NET 30		Aug-25-08		Aug-27-08		15 26 EB	
CONTROLE DE QUALITE DU CLIENT REQUIS CUSTOMER QUALITY RELEASE REQ'D		<input type="checkbox"/>		CONTROLE DE QUALITE DE MAGNA REQUIS MAGNA QUALITY RELEASE REQ'D		<input type="checkbox"/>		PREPAYS PREPAID	
<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>		A PERCEVOIR COLLECT	
QUALITE - QUALITY		UNITE UNIT		N° DE COULÉE HEAT NUMBER		QTE LIVRÉE QTY SHIPPED		PRIX PAR PRICE PER	
A VENIR - S/O									
CORRECTION ORDERED									
10		pcs		63706708		840#		10 pcs 673371	
10		pcs		220065		420#		10 pcs 660961	
9		pcs		2160587		847		9 pcs 661591	
4		pcs		2057041		22#		4 pcs CH 1971	
1.00		Lot							
				304-2B SHEET 16GA 48 X 96					
				304-2B SHEET 22GA 48 X 96					
				6061-T6 ALUM 1/8 SQ X .120 "SQC"					
				USE MTR #CI159					
				6061-T6 ALUM 1/8 X 1 ANGLE					
				Fuel Surcharge					
				TOTAL :				1368 LBS	

LIBRE DE PAQ.
LIBER OF BOL'S

MTR AVEC COMMANDE
MTR'S-WITH ORDER

POSTE
MAIL

TÉLÉCOPIEUR
FAX

PACKING SLIP / BON D'EMBALLAGE

Age: 1

15:54:36

20080825

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

CUSTOMER ORDER NO.: 070943BB
CUSTOMER PART NO 9-125-1000

63876



MILL TEST REPORT

CUSTOMER: A.S.A. ALLOYS INC.
81 STEINWAY BLVD.
ETOBICOKE, ONTARIO M9W 6H6

SAMPLE (S) OF ALUMINUM

REPORT: 60316

DIE NO.	S-2228
DESCRIPTION	1" X 1" X 0.125" ANGLE
AL. ALLOY & TEMPER	6061/T6511
EXTRUDEX ORDER NO.	102404-2-A.11
SPECIFICATION	ASTM B221
SILICON %	0.63
IRON %	0.18
COPPER %	0.19
MANGANESE %	0.01
MAGNESIUM %	0.89
CHROMIUM %	0.06
ZINC %	0.01
TITANIUM %	0.01
ALUMINUM %	REMAINDER
ALLOY TYPE	6061
ALLOY CAST NO.	2BG041
YIELD STRENGTH (IN ksi)	41.9
TENSILE STRENGTH (IN ksi)	44.7
ELONGATION % IN 2"	15.1
HARDNESS (ROCKWELL 'F')	88.7 88.1 88.5

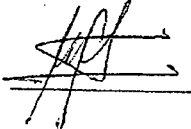
OK CP 02.12.11

CERTIFIED BY: _____

David Natale
(QUAL. MANAGER)

DATE: APRIL-17-08

SIGNED: _____


F. TABING
(LAB. TECH.)
APRIL-17-08

411 Chrislea Road, Woodbridge, Ontario. L4L 8N4 TEL:(416) 745-4444 FAX:(416) 745-0925